

Work Order ID 74716

Wednesday, October 05, 2011 12:58:35 PM

Page 1



Item ID: D4276-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4276	A								

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank to 36.630"
Batch: 120603

SL 12-02-29

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FB007
DWG REV: A
FOLIO REV: AA

SL 12-03-04



2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	12-03-04		4	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	or	12/03/05		4	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0	12/03/05	

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo MASK AS PER DWG M120222.	0.00 0.00				4	Q	28/12	12/03/05
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							4X SP M 12/03/06
180 Packaging Packaging	Identify as per dwg & Stock Location: 1108 Memo	0.00 0.00							4X SP 12-03-06

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/3/2011

012-03-6
(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 12:58:40 PM

Page 1

Work Order ID: 74716

Parent Item: D4276-1

Parent Item Name: Aft Beam



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	25.7870	3.052	12.85053			



6061-T6 Bar 1.00 x 4.00



SL 12-02-29

Location	Loc Qty	Loc Code
MAT004	25.787	
114352	1	
116808	0.787	
118400	24	

120603

12-9

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DART AEROSPACE LTD		Work Order:	74716
Description: Aft Beam		Part Number:	D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.749			Verh	SL-3
20.500	+/-0.010	20.500			m-tape	
Ø0.381	+0.000/-0.001	0.381			pin	
14.380	+/-0.010	14.380			H-G	
R0.75	+/-0.030	0.75				
3.50	+/-0.030	3.500			Verh SL-3	
16.38	+/-0.030	16.375			m-tape	
5.00	+/-0.030	5.00			Verh	SL-3
0.75	+/-0.030	0.750			-	
2.75	+/-0.030	2.751			-	
3.00	+/-0.030	3.00			-	
1.250	+/-0.010	1.249			-	
4.50	+/-0.030	4.50			-	
0.734	+/-0.010	0.735			-	
0.108	+/-0.010	0.109			H-G	
36.38	+/-0.030	36.38			m-tape	
0.95	+/-0.030	0.952			Verh	SL-3
0.60	+/-0.030	0.600				
2.70	+/-0.030	2.699				
1.10	+/-0.030	1.10				
1.25	+/-0.030	1.249				
0.75	+/-0.030	0.750				
3.000	+/-0.010	3.000				
1.500	+/-0.010	1.500				
Ø0.191	+0.005/-0.001	0.193				
2.300	+/-0.010	2.350				
3.50	+/-0.030	3.50				
R0.60	+/-0.030	0.600				
1.70	+/-0.030	1.699				
0.65	+/-0.030	0.650				

Measured by:	SL	Audited by:	AM	Preliminary Approval:	
Date:	12-03-04	Date:	12/03/05	Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	AM

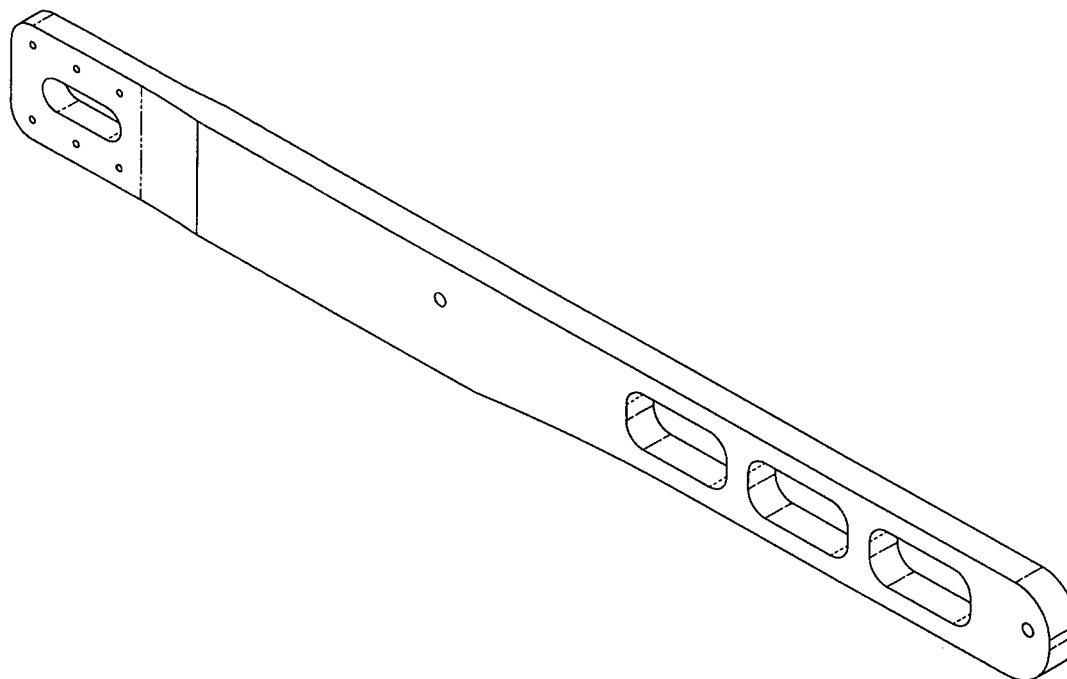
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NOTE: Date & initial all entries



D4276-1 AFT BEAM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 74716 M.C.J

11/10/05

RELEASE
2010-11-30
JMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A		NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4276 TITLE AFT BEAM			
DRAWN	JPH				
CHECKED	JPH				
MFG. APPR.	JPH				
APPROVED	JPH				
DE APPR.	JPH	REV. A SHEET 1 OF 1 SCALE NTS			
DATE	10.11.25			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REV. A
SHEET 1 OF 2

SCALE
NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

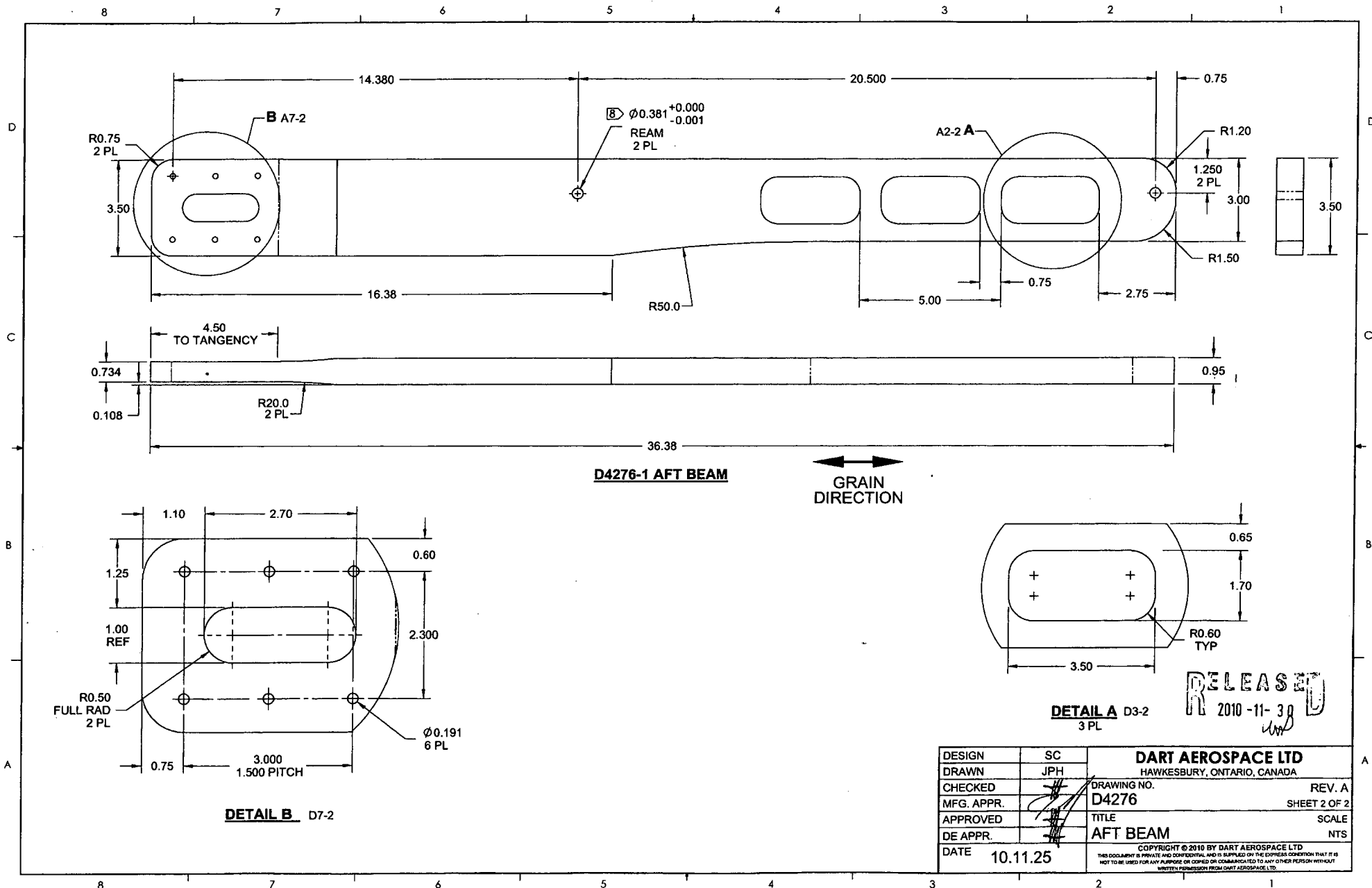
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